

DRAB GREEN

Dart Aerospace Ltd.

Date: Friday, 21/11/2008 11:42:05 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 X-TUBE INST,LOW NARROW FWD
 Job Number : 43686
 Estimate Number : 12816
 P.O. Number :
 This Issue : 21/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : CROSSTUBES
 Previous Run : 39535
 Part Number : D412664105DG
 Drawing Number : D412-664-145 REV C
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 05/12/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-04-05 JLM
 Est Rev:B 08-05-29 add procedures to Est. DD verified by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



H Cor JD 08.12.08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP-D412-664-105 CHG001

S 08/12/08

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

3.0

D412664105TRN

Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B39548

DP 8-11-26

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-145 using CNC bender program

DP 8-11-26

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/11/27 @

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

- 1- Mark cut lines
- 2- Cut tube to height as per dimension sheet
- 3- Scribe tube with R# and B#

> DP 8-11-27

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: 412 X-TUBE INST, LOW NARROW FWD

Job Number: 43686

Part Number: D412664105DG

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|------|------------------------------|
| 7.0 | QC15 | DIMENSIONAL CHECK OF X-TUBES |
|-----|------|------------------------------|



Comment: DIMENSIONAL CHECK OF X-TUBES

08/11/07

| | | |
|-----|------------|-----------------------|
| 8.0 | CROSSTUBES | CROSSTUBES RESOURCE 1 |
|-----|------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-245

2-Ream hole to finish size in tube as per Dwg D412-664-245

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-245

AWM 08-11-28
8-11-28

| | | |
|-----|-----------------|----------------------------|
| 9.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat Tube as per QSI 005 4.1

AWM 8-11-28

| | | |
|------|-----|---|
| 10.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|------|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/12/01

| | | |
|------|-----|------------------------------|
| 11.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

08/12/01

| | | |
|------|-----------------|-------------------------|
| 12.0 | OUTSIDE SERV.10 | OUTSIDE SERVICES -skids |
|------|-----------------|-------------------------|



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 7725 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

08/11/02 ①

| | | |
|------|-------------|-----------------------|
| 13.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

08/12/01

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Drawing Name: 412 X-TUBE INST, LOW NARROW FWD

Job Number: 43686

Part Number: D412664105DG

Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

08-12-03 (1)

15.0

SPRAY PAINTING

SPRAY PAINTING



M104476



(2X)

Comment: SPRAY PAINTING

M-L 08/12/04

1-Prime inside and outside crosstube as per QSI 005 4.2

BASE Glasurit Drab Green

2-Paint outside crosstube with White Iron as per QSI 005 4.2

M 08 12 03 (1)

16.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

08-12-04 (1)

17.0

D31893

Chafing Shield



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Chafing Shield

Batch: 31656

M 08 12 05

18.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

Batch: 41106

RT 08-12-04

19.0

D28931

2.75 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

PULL FROM STOCK 1 X D2893-1, BUFF LIGHTLY

REPAINT OLIVE DRAB GREEN B

Qty Part number Description Batch

2 D2893-1

Support 39527

M104476 M-L 08/12/04
M 08 12 04 (2)

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Job Number: 43686

Part Number: D412664105DG

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D2856600

Abrasion Strip



Comment: Qty.: 0.9450 f(s)/Unit Total: 0.9450 f(s)

Abrasion Strip

1X D2856 .250" X 8.42"

Batch: 37667

ml 08.12.05

21.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 107441

ml 08.12.05

22.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp(per MIL-DTL-8783C)

Batch: 109644

ET 08-12-04

23.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-145

1-Install Chaffing Shield - ml 08.12.05

2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

3-Instal supports with magnobond 6398 per dwg D412-664-245,
cure for 12hrs before packaging.

Time & date of application:

4/00 08.12.04

Batch: 108966

ET 08.12.04

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08.12.05 (70)

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 43686

Part Number: D412664105DG

Job Number:



Seq. #: Machine Or Operation: Description :

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

26.0 AN635A BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: 109282

SS 08/12/08 (X)

27.0 AN636A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)
Bolt
Batch: 109632

SS 08/12/08 (X)

28.0 MS21042L6 Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)
Nut
Batch: M106183

SS 08/12/08 (X)

29.0 AN960JD616 Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)
Washer
Batch: M109371

SS 08/12/08 (X)

30.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/12/08 (X)

31.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Identify and pack for shipping as per PPP D412-664-105

DART 08/12/08 (X)

| W/O: | | WORK ORDER CHANGES | | | | | | |
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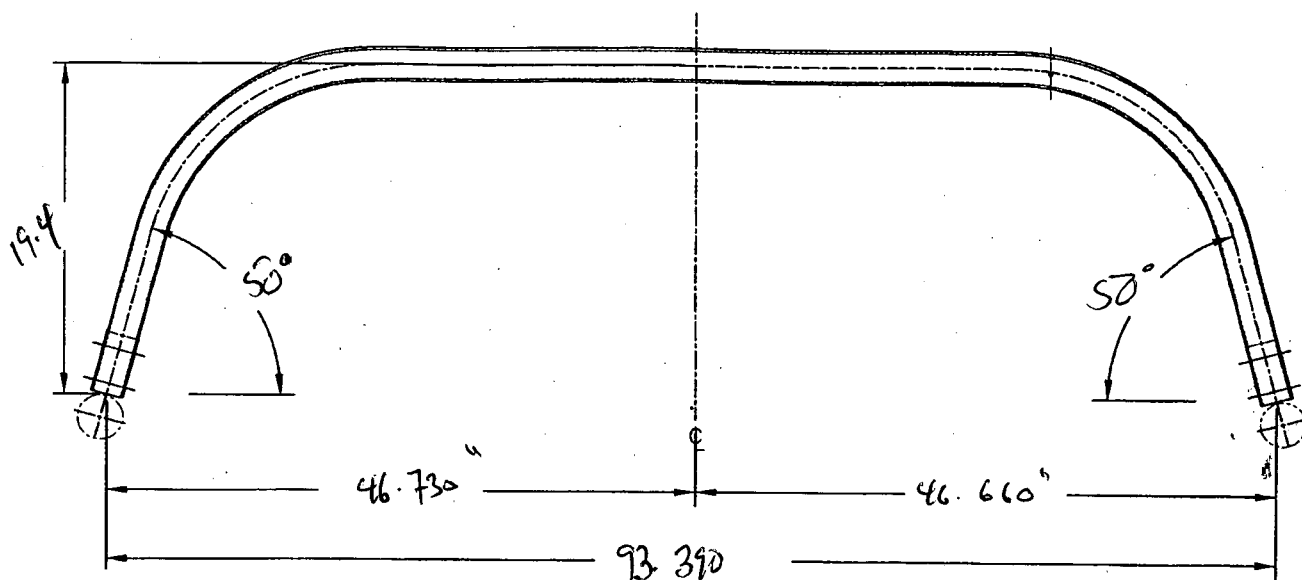
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NOTE: Date & initial all entries

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|--|--|----------------------------------|
| DART AEROSPACE LTD | | Work Order: 43686 |
| Description: Crosstube Low Narrow Fwd (412) | | Part Number: D412-664-105 |
| Inspection Dwg: D412-664-145 Rev: C | | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 19.23 | 19.49 |
| 1/2 Span | 46.47 | 46.73 |
| Angle | 49° | 52° |
| Total Span | 92.94 | 93.46 |



| Comments |
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| | |
|-----------------|----------|
| QC15 Inspection | 08/11/27 |
| Date | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.04.27 | New Issue | KJ/JM | |

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>qp</i> | DRAWN BY <i>qp</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D412-664-145 | REV. C SHEET 1 OF 3 |
| DATE 07.03.29 | | TITLE CROSSTUBE ASS'Y (412 LOW-N FWD) NTS | |
| A | 06.12.21 | NEW ISSUE | |
| B | 07.03.01 | CHG RUBBER CUSHION | |
| C | 07.03.29 | CHG CLAMP & RUBBER CUSHION LGTH. | |

RELEASED07.04.24 *[Signature]***PARTS LIST:**

| Qty | Part Number | Description |
|-----|----------------|---|
| X | D412-664-145 | CROSSTUBE ASSEMBLY (412 LOW-NARROW FWD) |
| 1 | D6019-128 | CROSSTUBE |
| 1 | D2856-250-842 | ABRASION STRIP |
| 2 | D2893-1 | SUPPORT |
| 1 | D3189-3 | CHAFING SHIELD |
| 4 | D3595-063-450 | RUBBER CUSHION |
| 2 | MS21920-24 | CLAMP |
| 4 | MS21920-25 | CLAMP (OR MS21920-26) |
| A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6019-128
FINISHED LENGTH = 124.48 ± 0.020 (BEFORE BENDING/TRIMMING)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE, EXCEPT FOR D3189-3 CHAFING SHIELD AND ASSOCIATED HARDWARE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-XXX-YYY ABRASION STRIPS WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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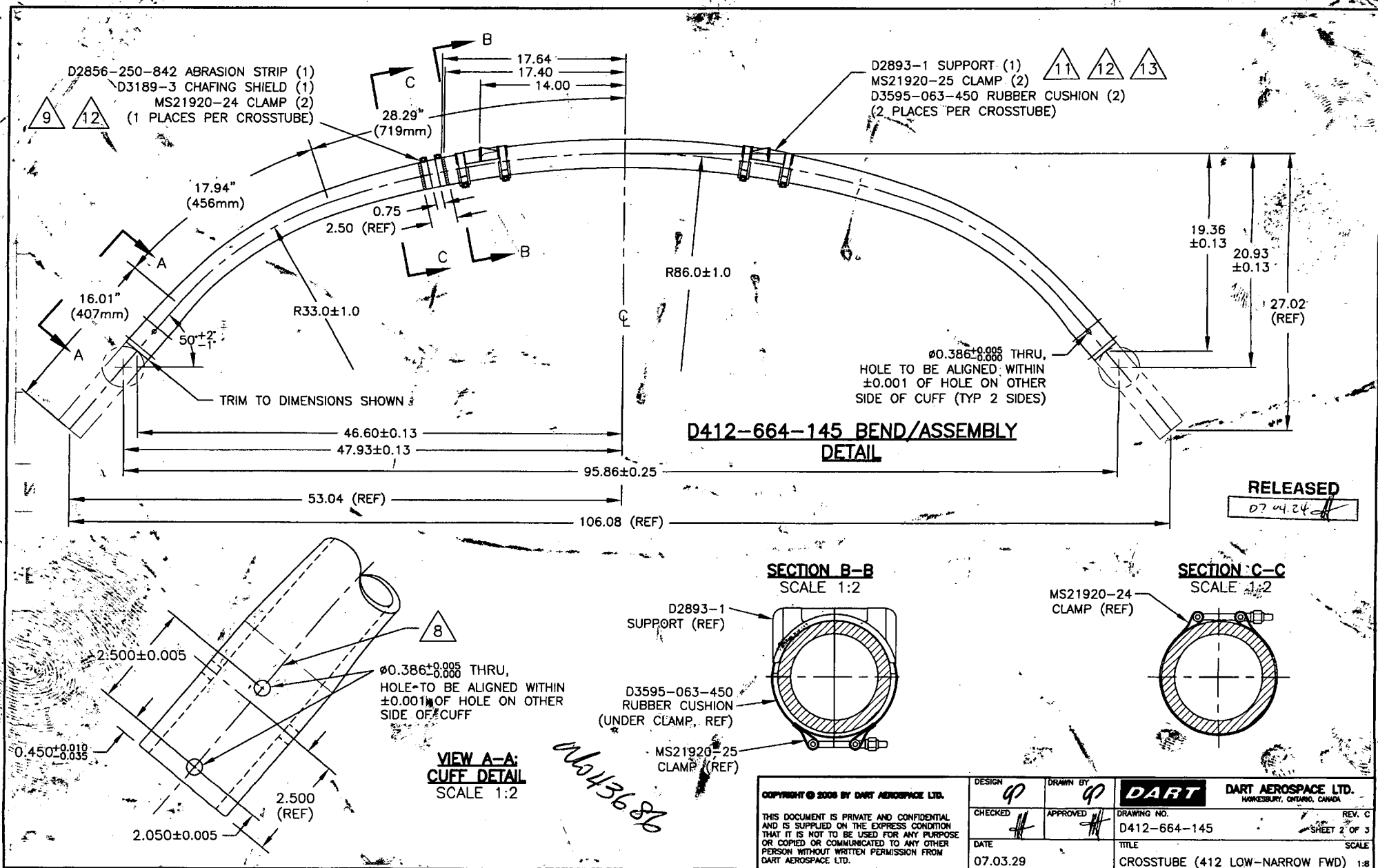
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L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: November 19, 2008 10:43 AM
To: 'David Shepherd'
Cc: 'L Lacelle'; moreilly@eaglecopters.com; 'Peggy McDonald'
Subject: RE: Canadian DND

David,
Thanks for the help.
Bill

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: November 19, 2008 10:25 AM
To: 'Bill Beckett'
Cc: 'L Lacelle'; moreilly@eaglecopters.com; 'Peggy McDonald'
Subject: RE: Canadian DND

Bill,

I called Peggy on her cell phone this morning because we didn't get a response yesterday. She is travelling and having some email problems. Apparently, DND has requested Drab Green to distinguish the Dart gear from the OEM gear.

I have consulted the paint shop here at Eagle. They use a BASF Glasurit Paint system. This is the same type of paint we ended up using on the Glareshields. The brochure I am looking at shows a 754247 Olive Drab, but I'm not sure how well it matches the powder you are using on the skidtubes.

Suggest that you send me your "Drab Green" chip and we can do some comparisons here. If it doesn't quite match, the boys can play with the mixture here to try to get it to match. They can then give you the exact formula to order.

I talked to Linda about this and this seemed to make sense to her. Therefore, unless I hear differently, I am expecting an "Olive Green" paint chip to arrive at Eagle tomorrow.

David

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: Wednesday, November 19, 2008 7:08 AM
To: 'Peggy McDonald'
Cc: 'L Lacelle'; 'David Shepherd'
Subject: RE: Canadian DND

Peggy,
The paint is becoming a pacing item. We need confirmation ASAP as to whether it will be Eagle Black or Drab Green.
Please let us know.
Thanks,
Bill

From: David Shepherd [mailto:dshepherd@dartaero.com]

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